



Dart Aerospace Ltd.
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Canada

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③

D119-796-241TRN
Job Sheet 174956



Part No: D119-796-241TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 6/13/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV J IPP REV A RQ 14/05/27 VERIFIED BY DD IPP REV:B 16.05.04 AS PER DWG REV.I DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/12/18	0.00	0.00	Start Up Crosstubes-1		M.D.
100	Mori Seiki	1 pcs		6/12/18	1.77	1.72	Mori Seiki TL-40		M.D.
110	QC	1 pcs		6/12/18	0.00	0.00	QC2-1		M.D.
120	Mori Seiki	1 pcs		6/12/18	0.00	1.72	Mori Seiki TL-40		M.D.
130	QC	1 pcs		6/12/18	0.00	0.00	QC2-1		M.D.
140	QC	1 pcs		6/12/18	0.00	0.00	QC8		GP 18-06-07
145	Crosstubes	1 pcs		6/12/18	0.00	0.45	Crosstubes-1		GP 18-06-07
150	HandFXtube	1 pcs		6/13/18	0.00	0.33	Crosstubes-3		GP 18-06-07
160	QC	1 pcs		6/13/18	0.00	0.00	QC7-1		GP 18-06-07
170	Packaging	1 pcs		6/13/18	0.00	0.00	Packaging3-1		GP 18-06-07
180	QC21-FG	1 Ea		6/13/18	0.00	0.00	QC21		

Part Op 100 - 1-Fill tube with sand & install plugs on both ends as per Folio FB298 2-Turn first side as per Folio FB298
Descriptions: 120 - 1-Turn second side as per Folio FB298
145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - 1- handfinish X-TUBE INSIDE AND OUT
170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6023-106	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

B150731

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6023-106	1	39	0

Part Specifications

Specifications could not be found.

Plex 3/23/18 10:32 AM Dart.Gagnon.Michelle



Container No: S078274



Part: D119-796-241TRN

Job No: 174956

Serial No/Batch: S078274

Revision:

Inspector:

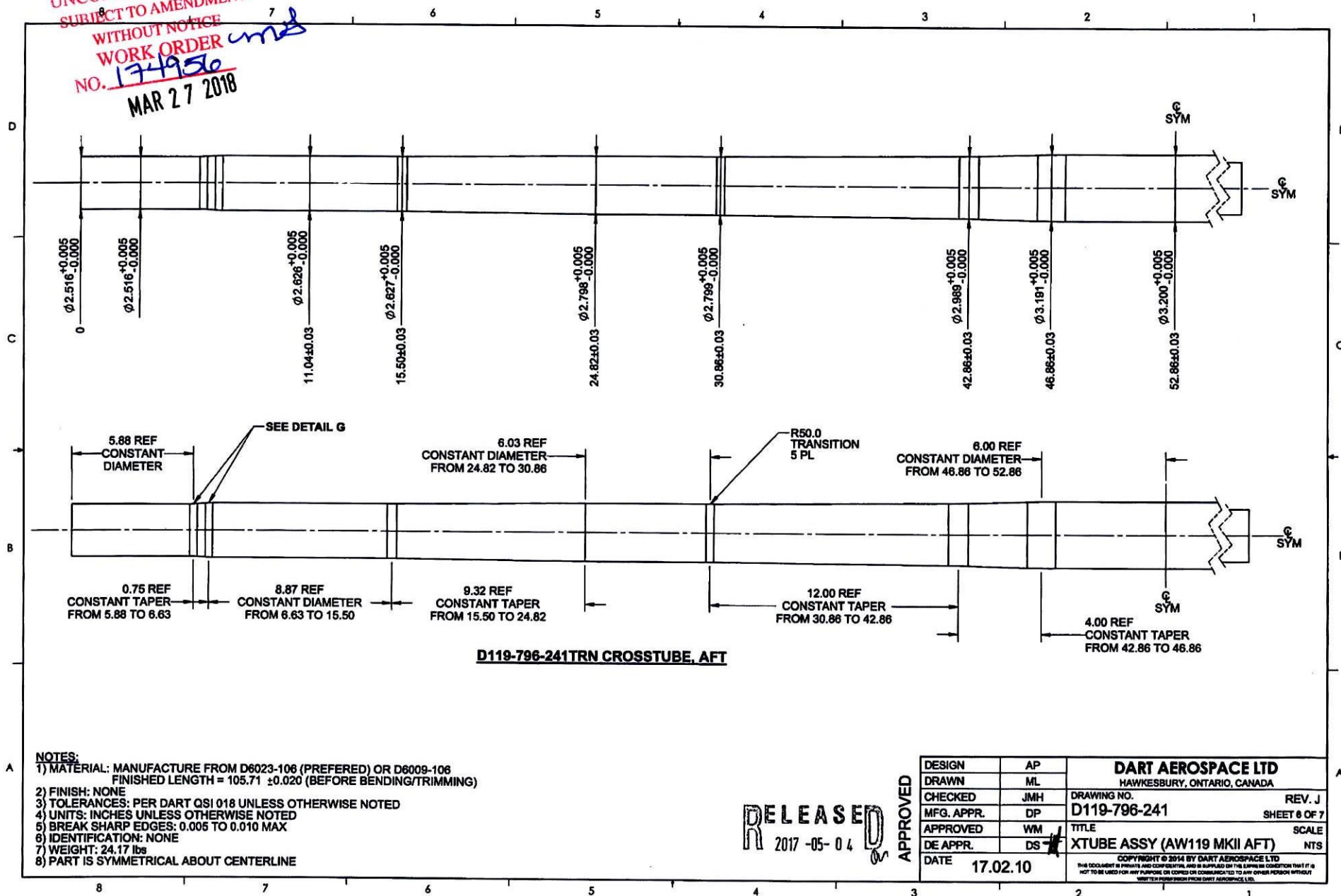
Exp Date: 06/05/2018

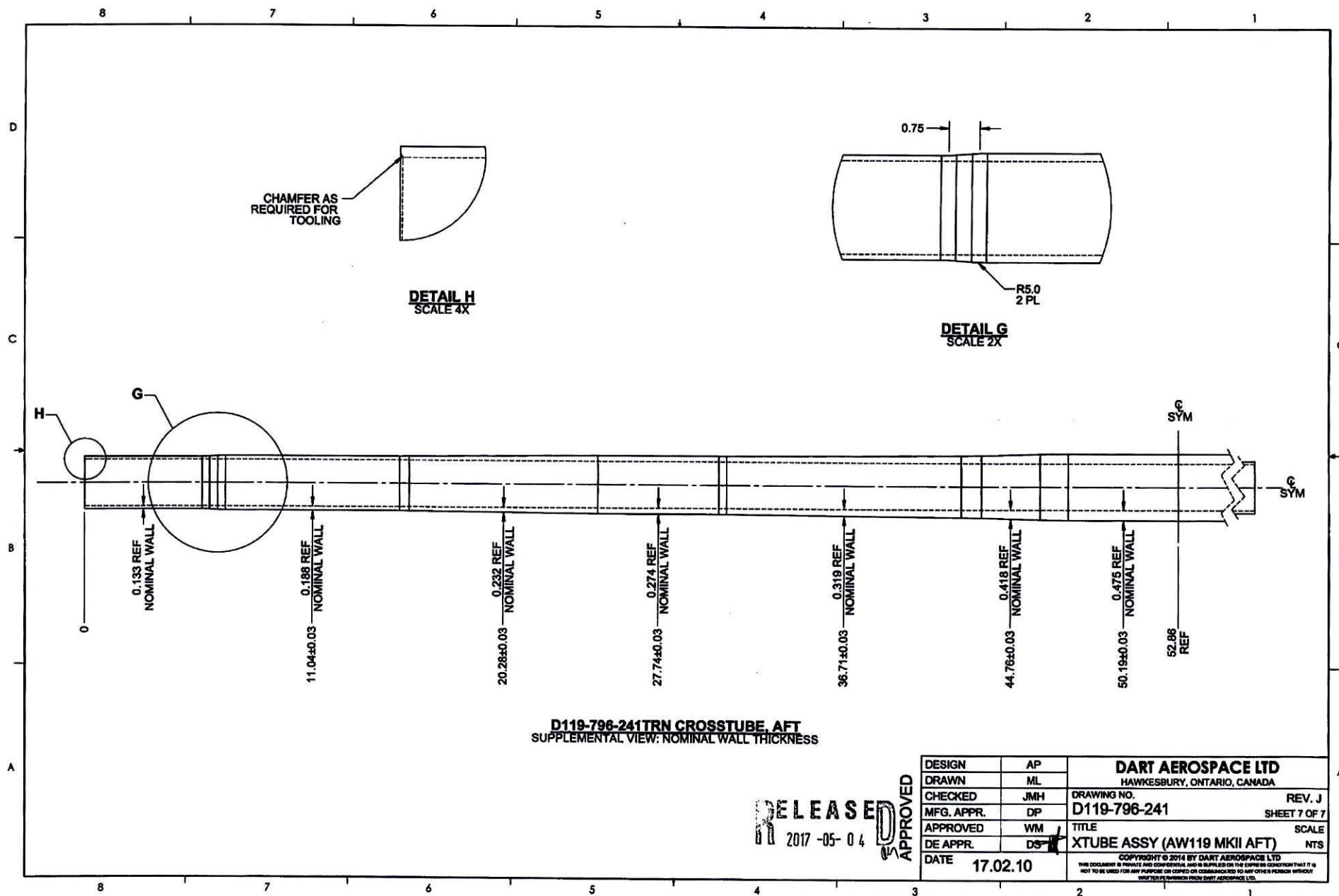
Instructions:

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TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/05/18

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 174956
MAR 27 2018





RELEASED
2017-05-04

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 7 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DART AEROSPACE LTD	Work Order:	174956
Description: Crosstube Assembly (AW119 MKII Aft)	Part Number:	D119-796-241TRN
Inspection Dwg: D119-796-241 Rev: J		Page 1 of 2

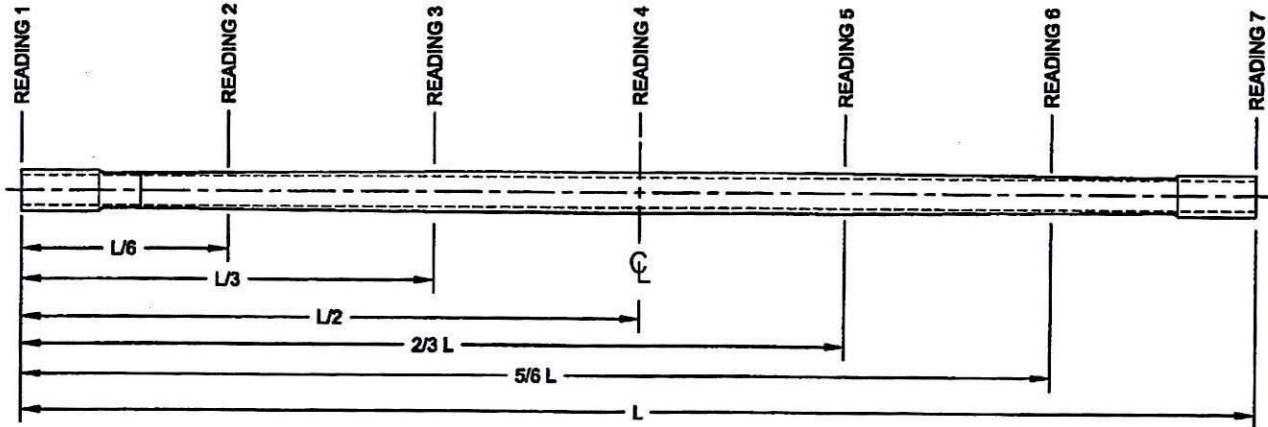
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	5.88	+/-0.030	5.880	✓		Vern 08	
	2.516	+0.005/-0.000	2.521	✓		BLM3" 04	
	2.626	+0.005/-0.000	2.631	✓		"	
	2.627	+0.005/-0.000	2.632	✓		"	
	2.798	+0.005/-0.000	2.803	✓		"	
	2.799	+0.005/-0.000	2.803	✓		BLM3" 04	
	2.989	+0.005/-0.000	2.993	✓		"	
	3.191	+0.005/-0.000	3.196	✓		BLM4" 05	
	3.200	+0.005/-0.000	3.205	✓		Vern 08	
SIDE B	5.88	+/-0.030	5.881	✓		Vern 08	
	2.516	+0.005/-0.000	2.521	✓		BLM3" 04	
	2.626	+0.005/-0.000	2.631	✓		"	
	2.627	+0.005/-0.000	2.632	✓		"	
	2.798	+0.005/-0.000	2.803	✓		"	
	2.799	+0.005/-0.000	2.803	✓		BLM3" 04	
	2.989	+0.005/-0.000	2.992	✓		"	
	3.191	+0.005/-0.000	3.196	✓		BLM4" 05	
	3.200	+0.005/-0.000	3.205	✓		Vern 08	
	105.71	+/-0.020	105.71	✓		Tape	

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DART AEROSPACE LTD	Work Order: 17495.6
Description: Crosstube Assembly (AW119 MKII Aft)	Part Number: D119-796-241TRN
Inspection Dwg: D119-796-241 Rev: J	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.132	.126	.128	.127	.006	0.030"
READING 2 L= 17.62	.212	.203	.190	.197	.022	
READING 3 L= 35.24	.313	.304	.290	.297	.023	
READING 4 L= 52.86	.474	.476	.486	.483	.012	0.063"
READING 5 L= 70.47	.302	.311	.303	.291	.020	
READING 6 L= 88.09	.201	.197	.198	.205	.008	
READING 7 L= 105.71	.129	.113	.121	.141	.028	

Calibration Result

Actual Block Thickness: 100-500

Sitescan 250 Measured Thickness: 100-500

Measured by: M.D. PAMP	Audited by: GP TW	Preliminary Approval:
Date: 2018-06-05	Date: 18-06-06	Date:

Rev	Date	Change	Revised by	Approved
A	14.09.18	New Issue (P/O D119-796-201)	KJ	
B	15.03.12	Dimensions updated per Dwg Rev F	KJ	
C	15.04.14	Tolerance dimensions revised on Wall Thickness table	KJ	
D	15.05.14	Tolerances revised per Dwg Rev G	KJ	
E	15.09.09	Dwg Rev updated	KJ	
F	16.05.27	Dwg Rev updated	KJ	
G	17.07.12	Dwg Rev updated	KJ	